

M303 H.500

Work Order ID 150688

Monday, August 29, 2016 3:01:14 PM

150688

Page 1

Item ID: D3622-15 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Ball Stud

Start Date: 8/25/2016 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: DAS Date: AUG 30 2016 Tooling: _____ Date: _____ Run Start *NR1*

QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3622	D								DAS 49 9-89
100	Hardinge CNC LATHE SMALL	0.08				10	0		16/09/12
100									
Hardinge	Memo	0.20							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO F _____ & DWG D3622, FOLIO REV: <u>3A</u> DWG REV: <u>D</u> 2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		DAS 49 9-89 16/09/12
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00				10	0		DAS 08 9-89
120									
QC	Memo	0.03							
Quality Control									

B.o 16/09/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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150688

Page 2

Item ID: D3622-15

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ball Stud

Start Date: 8/25/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: Store

0.00

130

Packaging

Memo

0.02

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.17

Quality Control

DAS
21
9-89

SEP 13 2016

16/9/13

DAS
21
9-89

SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

Monday, August 29, 2016 3:01:13 PM

Page 1

Work Order ID: 150688

150688

Parent Item: D3622-15

D3622-15

Parent Item Name: Ball Stud

Start Date: 8/25/2016

Required Date: 8/29/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 16.04.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No				f	2.6300		1.294737			

M303H0 500

303 HEX BAR .500

Location

MAT018

m134984

Loc Qty

2.63

2.63

Loc Code

1.08

DAS
49
9-89

16/09/12

DQA: _____ Date: _____

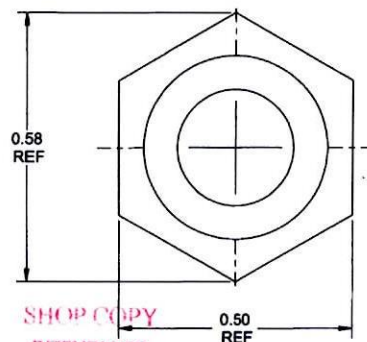


WORK ORDER NON-CONFORMANCE / UPDATE

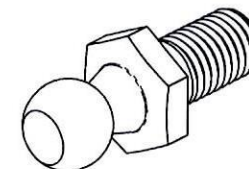
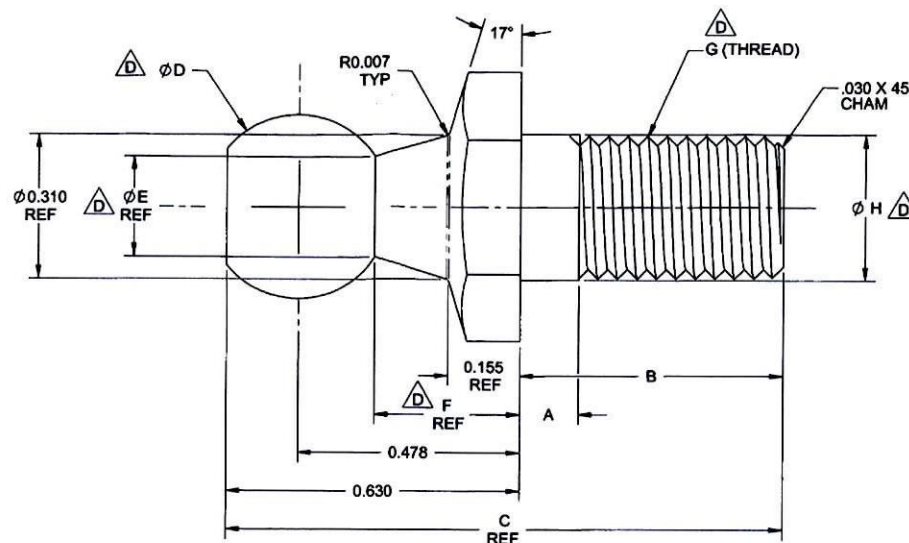
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Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐															
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐															
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐															
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐															
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐															
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐															
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐															
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :																						
Misidentified ☐	☐	Past Due ☐																							



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**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	DIM D	DIM E	DIM F	WEIGHT (LBS)	THREAD G	MIN Ø H	MAX
D3622-1	0.125	0.563	1.19	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.394	0.215	0.313	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.394	0.215	0.313	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.394	0.215	0.313	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.394	0.215	0.313	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-15	0.090	0.430	1.06	0.350	0.202	0.334	0.02	M6 X 1.0	5.82mm	6.00mm

D3622-X BALL STUD

NOTES:

- MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- FINISH: N/A
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- WEIGHT: SEE D3622-X TABLE

RELEASED
2016-04-18
ECN 16-557

APPROVED

D	ADDED -15, ADDED COLUMN D, E AND F. RENAMED SUBSEQUENT COLUMNS.	AK	16.03.15
C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	JL		
APPROVED	HS		
DE APPR.	DS		
DATE	16.03.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3622** REV. D
SHEET 1 OF 1
TITLE **BALL STUD** SCALE NTS

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